

Work Order ID 83507

Thursday, April 19, 2012 10:24:38 AM

83507

Page 1

Item ID: D3201-4

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/19/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: Date: 12-04-19Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3201	Rev B					(19)			

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201

Dwg Rev: BProg Rev: B

2-Deburr if necessary

2674.050

B12-5-22

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B12-5-22

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8.215122

(714)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

19 Sgt 12/5/23

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Picklist Print

Thursday, April 19, 2012 10:24:43 AM

Page 1

Work Order ID: 83507

83507

Parent Item: D3201-4

D3201-4

Parent Item Name: Doubler

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
 IPP Rev:B Now on Waterjet 06-08-14 JLM
 IPP Rev :C Added scribing, NCR262 07.11.29 EC IPP Rev:D
 10.10.29 remove scribe b# & p# DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	119.2000	0.045	0.378947	1.		

M2024T3S 050

2024-T3 .050 sheet

**

B12-5-06

Location

Loc Qty

Loc Code

MAT022

119.2

117684

24.9

121216

94.3

121216

18

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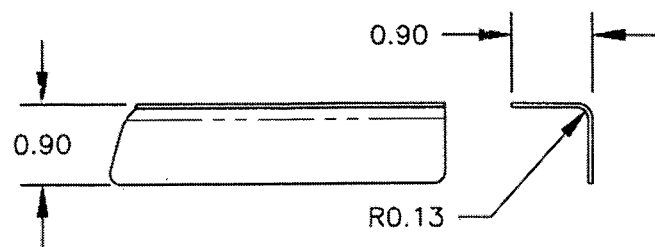
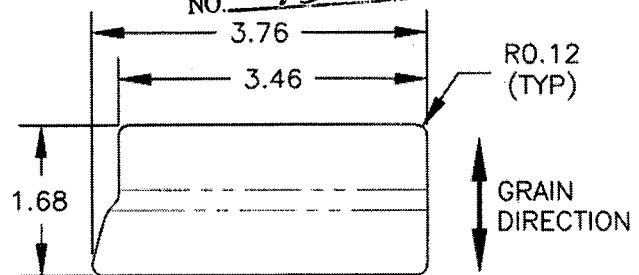
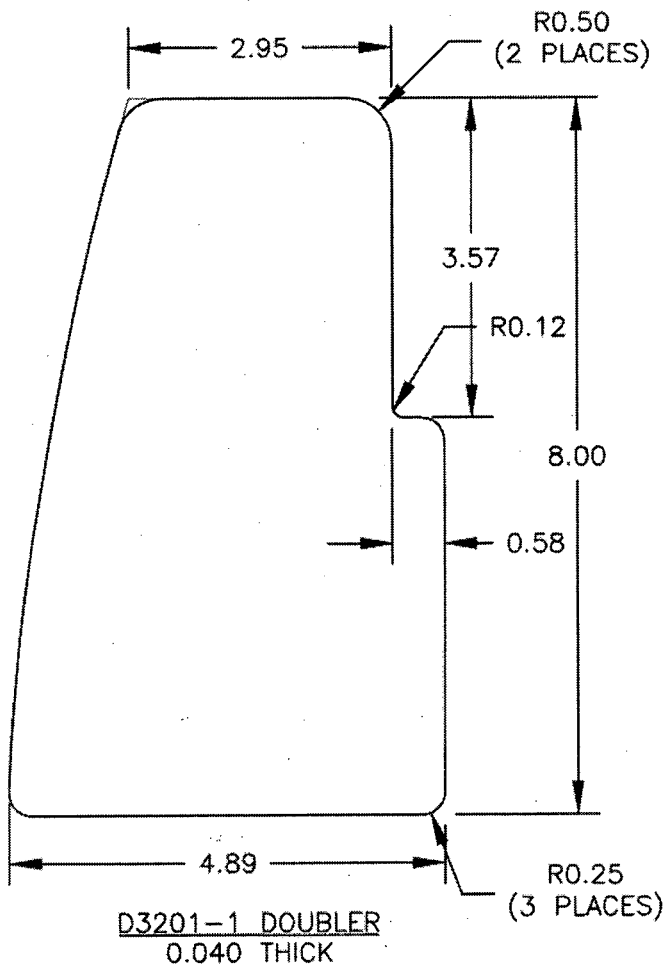
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83507

12-04-19**D3201-1/-3/-4 DOUBLER**

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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